



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6305G11331-3G-13

Job Sheet 178404



Part No: RBW6305G11331-3G-13

Job Qty: 6 ea

Part Name: Socket



Part Weight: 0 lbs

Status: At Planning

Priority: High

Job Created: 5/31/18

Job Tracking No:

Due Date: 6/11/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBW6305G11331-3G Rev. C IPP Rev. A 18.05.09 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	6/11/18	6/11/18	0.00	0.00	Start Up Machining-3		SL 18-6-17
120	CNC Lathe	6 pcs	6/11/18	6/11/18	0.00	4.20	MORI SL-154		SL
130	QC	6 pcs	6/11/18	6/11/18	0.00	0.00	QC2 Machining-4		SL
140	QC	6 pcs	6/11/18	6/11/18	0.00	0.00	QC8 Machining-4		SL
170	Outsource	6 pcs	6/11/18	6/11/18			GRO002-VC	10	SL 18-06-18 CC 18-6-18
180	Packaging	6 pcs	6/11/18	6/11/18	0.00	0.00	Packaging2		DAS
190	QC	6 pcs	6/11/18	6/11/18	0.00	0.00	QC6		38
200	Packaging	6 pcs	6/11/18	6/11/18	0.00	0.00	Packaging3-1		SP 18-06-22
210	QC21-SA	6 Ea	6/11/18	6/11/18	0.00	0.00	QC21		JUN 25 2018

Part Op 120 - 1-Machine as per DWG. FC 0913 FOLIO REV: DWG REV: 21 2-Deburr 3-REFER TO
Descriptions: 170 - -Issue P/O to Groupe Altech: P/O 040298 -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R1.750	AISI 4140 Quenched & Tempered Steel Round Bar 1.750" Dia.	2.0580 ft (.343 ea)	90-Start up Operation	5048045:1.03

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140QT-R1.750	2	13	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 6/11/18 9:25 AM dart.logan.david

Container No: S081671



Part: RBW6305G11331-3G-13

Job No: 178404

Serial No/Batch: S081671

Revision: C

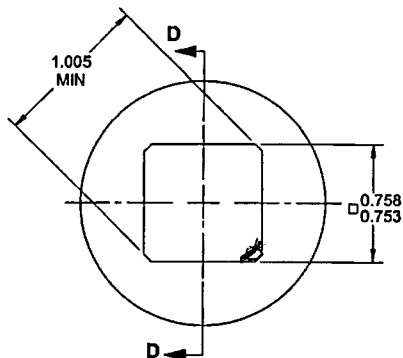
Inspector:

Exp Date:

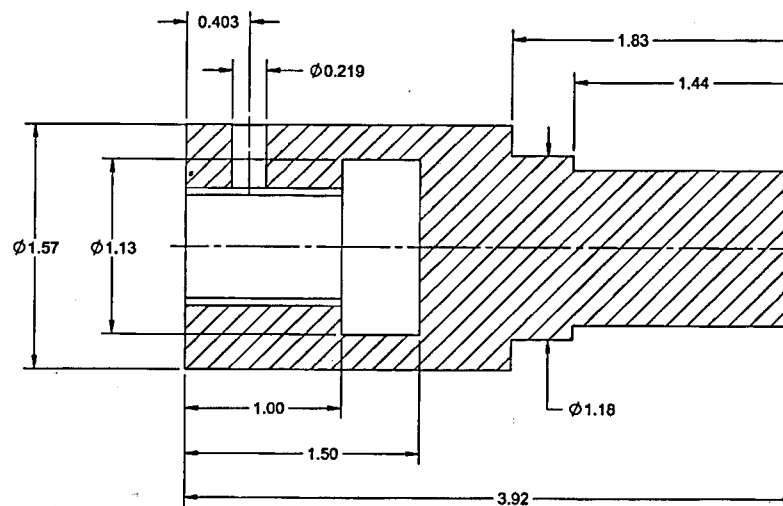
Instructions:

Date: 06/17/18

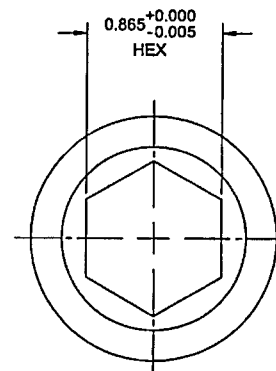
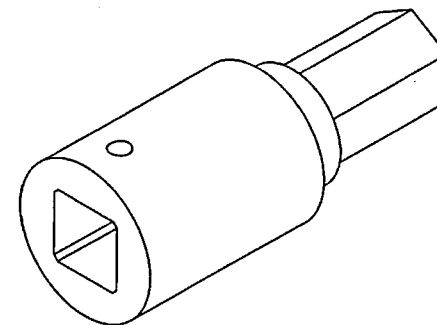
Salut Julien,
Nouvelle son
est cl.



RBW6305G11331-3G-13 SOCKET



SECTION D-D



NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

C	MISSING PART ADDED	18-538	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM 04/17/2018		
CHECKED	VM 04/17/2018	TOOL PART #	REV. C
MFG. APPR.	DP 04/18/2018	RBW6305G11331-3G	SHEET 8 OF 8
APPROVED	ML 04/24/2018	TITLE	SCALE
DATE 4/24/2018		MAIN GEAR BOX INPUT PINION RING NUT WRENCH	NTS
COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>177972</u> <i>MTL</i> Part No. <u>B3W630641331-35-13</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval <i>MTL</i> <u>05/18/18</u> Completed By			
Description Work Order Deviation BROACH REWELLS NOT MACHINED				Disposition BROACH REWELLS IS NOT REQUIRED FOR PROPER FUNCTION OF TOOL. THIS DEVIATION IS ACCEPTABLE				Lead hand / Supervisor Approval Verification	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☒ Process Improvement ☒ Manufacturing Process ☒ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																				
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																				
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																				
Large Fab ☐	Composite ☐	Supplier ☐																																																																					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																																																																
Description Work Order Deviation				Disposition				Completed By																																																															
								Lead hand / Supervisor Approval Verification																																																															
								QC / QA Coordinator Approval																																																															
Root Cause <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Environment ☐</td> <td style="width:12.5%;">No Re-verification ☐</td> <td style="width:12.5%;">Pressure/Forced ☐</td> <td style="width:12.5%;">Temperature/Cure ☐</td> <td style="width:12.5%;">Power Loss/Surge ☐</td> <td style="width:12.5%;">Positioned Wrong ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td colspan="4" rowspan="2" style="vertical-align: top;">OTHER : _____</td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> </tr> </table>				Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				Misidentified ☐	Past Due ☐
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																																																																		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																																																																		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																																																																					
Misidentified ☐	Past Due ☐																																																																						



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO040228

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040228
PO Date: 6/18/18
Due Date: 6/22/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
①	178404	RBW6305G11331-3G-13	Socket -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required	Firmed	6/22/18	3 pcs	0 pcs 3x	3 pcs	\$30.00/pcs	\$90.00
②	173927	RBE703A94-1130-01-11	Angle Indicator -Issue P/O to Groupe Altech: _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT - Certificate of Conformity is required	Firmed	6/22/18	12 pcs	0 pcs 12x	12 pcs	\$6.00/pcs	\$72.00
③	173933	RBE703A94-1130-01-31	Tab Adjuster Gauge Plate -Issue P/O to Groupe Altech: _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 Water Seal - Certificate of Conformity is required	Firmed	6/22/18	12 pcs	0 pcs 12x	12 pcs	\$6.00/pcs	\$72.00
④	173932	RBE703A94-1130-01-29	Tab Adjuster Clamp : URF 17-623 -Issue P/O to ATG: _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 - Certificate of Conformity is required	Firmed	6/22/18	12 pcs	0 pcs 12x	12 pcs	\$6.00/pcs	\$72.00
Grand Total:										\$306.00

Order Notes

rec'd.
JUN 20 2018
mgl.

CT.



Certificat de Conformité / Certificate of Compliance

(010381-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

010381- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
20-Jun-2018		Jessie Boisvert		040228				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW6305G11331-3G-13 Rev.	RBW6305G11331-3G-13 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS TYPE 1 SC2 ASTM B633	ZINC CH	3	3	0 ✓	0	0
2	RBE703A94-1130-01-11 Rev.	RBE703A94-1130-01-11 MIL-A-8625F TYPE 2 CLASS 1 CLEAR ANODIZE	ANODIZE CH	12	12	0 ✓	0	0
3	RBE703A94-1130-01-31 Rev.	RBE703A94-1130-01-31 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	12	12	0 ✓	0	0
4	RBE703A94-1130-01-29 Rev.	RBE703A94-1130-01-29 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	12	12	0 ✓	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.